

## ABSTRACT

Radiation-curable formulation substantially-free of volatile organic compounds (VOCs), the formulation comprising

- (a) from about 5% to about 70% by weight of an a monomer diluent comprising at least one activated unsaturated moiety;
- (b) optionally up to about 10% by weight a photo-initiator; and
- (c) from about 30% to about 95% by weight of at least one polymer and/or oligomer obtained and/or obtainable from a monomer comprising at least one activated unsaturated moiety,

where the formulation and/or components thereof exhibit at least one of the following properties:

- (w) the polymer component (c) has a solubility parameter (heat of fusion per unit volume) of more than about  $15 \text{ J}^{1/2}\text{cm}^{-3/2}$ ;
- (x) the polymeric component (c) has a number average molecular weight ( $M_n$ ) of less than about 15,000 daltons;
- (y) the formulation has a viscosity of up to about 10,000 centipoise and no more than 50% of diluent; and/or
- (z) the polymeric component (c) having a dispersing power ( $\Theta$ ) of up to about  $1.0 \text{ DP}(\text{equivalents}) / (\text{mol} \times \text{daltons})$ .